

Date: Tuesday, 11/29/2005 7:09:41 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 25059		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D3389 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>Est. A. 05.08.31</u>	Due Date	: 12/9/2005
Checked & Approved By	: <u>New Issue KT/JLM</u>	Qty:	5 Um: Each
Comment	: Created By Auto Work Order		

Additional Product:

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D25003100 Ext'n -1' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty Part Number  
1 D2500-3-100Description Batch  
Web Extrusion

Batch

B21570 PM'05-12-13

Tools:

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3389

Drill pilot holes using DT8785 as per Dwg D3389

Open holes to finish size as per Dwg D3389

Deburr

} PM'05-12-13

Tools:

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Tools:

BE 05-12-14

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A m 05-12-14

Tools:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 05/12/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services      Drawing Name: 412 WEB

Job Number: 25059      Part Number: D33891

Job Number: 

Seq. #:      Machine Or Operation:      Description :  
5.0      QC3      INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION      DP 05-12-14

Tools:

6.0      PACKAGING 1      PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: LG A.M 05-12-14

Tools:

7.0      DC      DOCUMENT CONTROL

Comment: DOCUMENT CONTROL      Inspection Level 21      SAC 05/12/14      (S)      05/12/15 (S)

Tools:

Job Completion 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

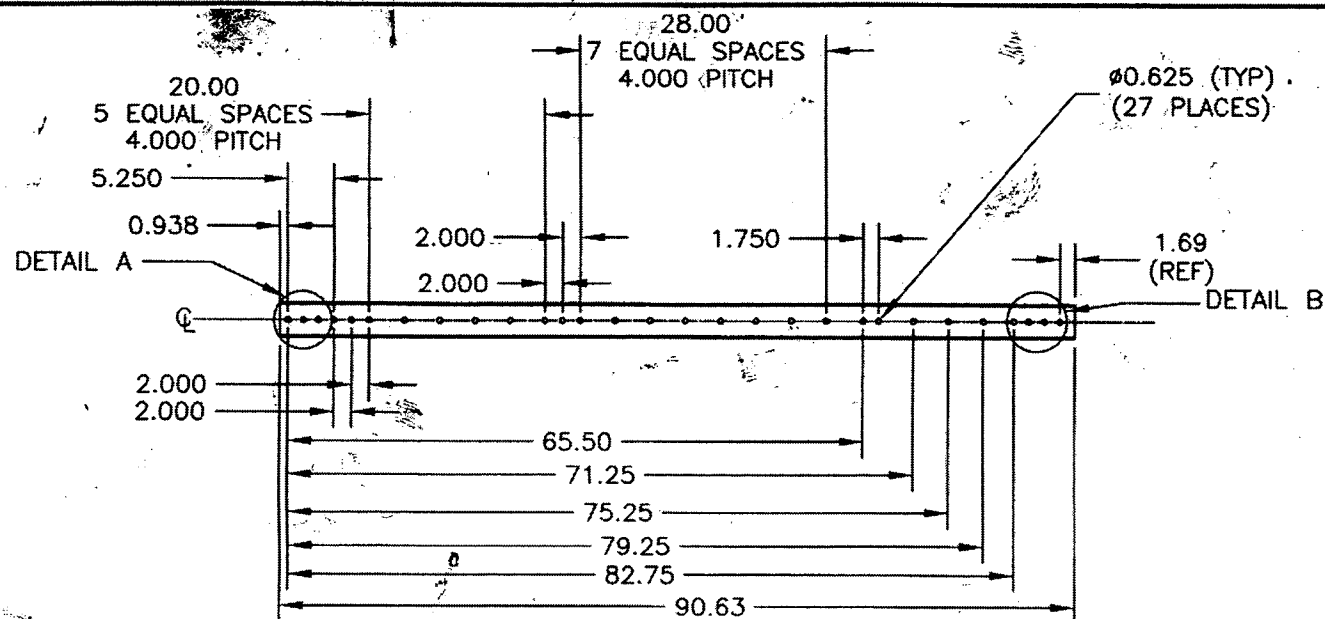
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

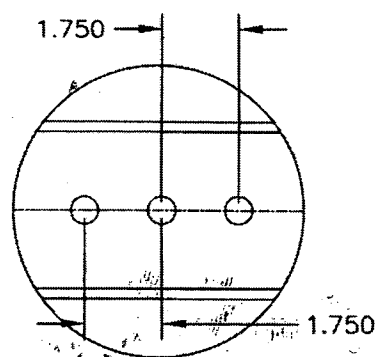
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NOTE: Date & initial all entries

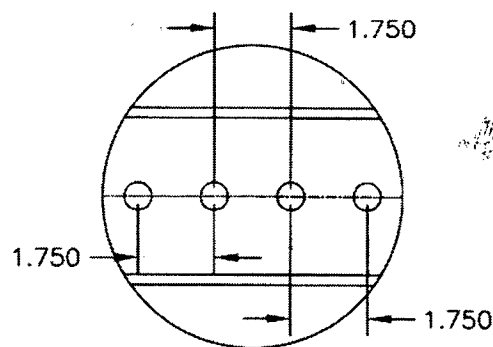
# DART



**D3389-1 DRILLING DETAIL**



DETAIL A  
(SCALE 1:4)





DETAIL B  
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05-08-09

DESIGN PH		UNIFORM BY PH	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO. D33389 SHEET 1 OF 1 REV. B
DATE	05.06.13		TITLE	SCALE
			412 WEB	1:20
A		05.02.07	NEW ISSUE	
B		05.06.13	UPDATE DIMENSIONING	

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